

Work Order ID 56190

February 12, 2010 10:37:39 AM



Page 1

Item ID: D3852-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 2/12/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-2-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3852

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

- 1- pick D3166-3 to cut D3852-2 rib (RH) as per dwg D3852 using DT9440 jig
- 2- drill hole (3/16") in D3852-2 using DT9439 jig and open to finish size as per dwg D3852
- 3- c'sink hole as per dwg
- 4- remove identification markings
- 5- deburr
- 6- weld D3759-1 bushing as per dwg D3852
- A/R ER316 S.S. Rod Batch: M109213
- 7- grind bushing weld flush as per dwg dwg D3852
- 8- deburr hole if necessary

SAD 10-02-23

10.03.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56190

February 12, 2010 10:37:39 AM



Page 2

Item ID: D3852-042

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Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 2/12/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

②

PD 10.03.01



QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00

S w/03/11



QC

Memo

0.00

Quality Control

42
7042

150

Identify as per dwg & Stock Location: basket

0.00



Packaging

Memo

0.00

Packaging

②

PD 10.03.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 56190

February 12, 2010 10:37:39 AM



Page 3

Item ID: D3852-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 2/12/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03 HJ

PT 10-3-02

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

February 12, 2010 10:37:43 AM

Page 1

Work Order ID: 56190

Parent Item: D3852-042

Parent Item Name: Rib Assembly



Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Start Date: 2/12/10

Required Date: 2/18/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3166-3		Manufactured	No			100	Each	14.0000	0.3789			
												
Basket Hoop												

SAD 10-02-23

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 5

48429 5

Main Warehouse

WA 9.000014474

52058 1.4474E-05

54018 3

55697 6

0.3790

D3759-1

Manufactured No

100

Each

36.0000

2.0000



Bushing

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 36

53442 2

54072 9

55789 25

Plc 10.03.01

* @Plc

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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB

D3852-041 RIB ASSEMBLY

D3852-042 RIB ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54190
RS 10-2-12

RELEASE
08/11/08 MP

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.83 lbs EACH
8) WELDING: PER QSI 004

A	NEW ISSUE		MB	08.11.07
REV.	DESCRIPTION		BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.11.07			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3852** REV. A
SHEET 1 OF 3
TITLE **RIB ASSEMBLY** SCALE NTS

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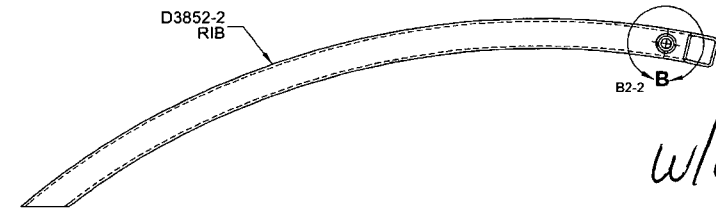
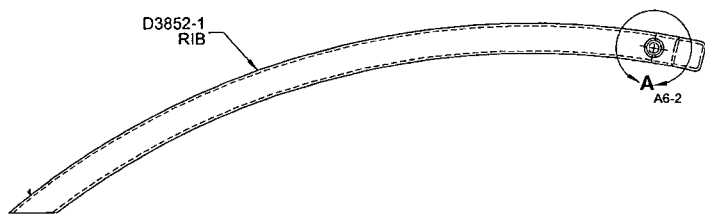
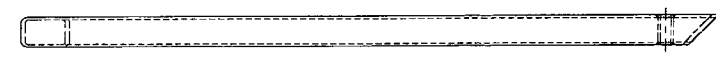
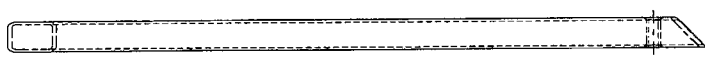
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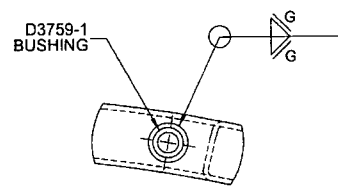
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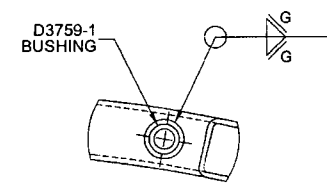
W/O 56190

D3852-041 RIB ASSEMBLY

D3852-042 RIB ASSEMBLY



DETAIL A
SCALE 2X C5-2



DETAIL B
SCALE 2X C2-2

RELEASED
08/11/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	125	DRAWING NO. D3852	REV. A
MFG. APPR.		SHEET 2 OF 3	
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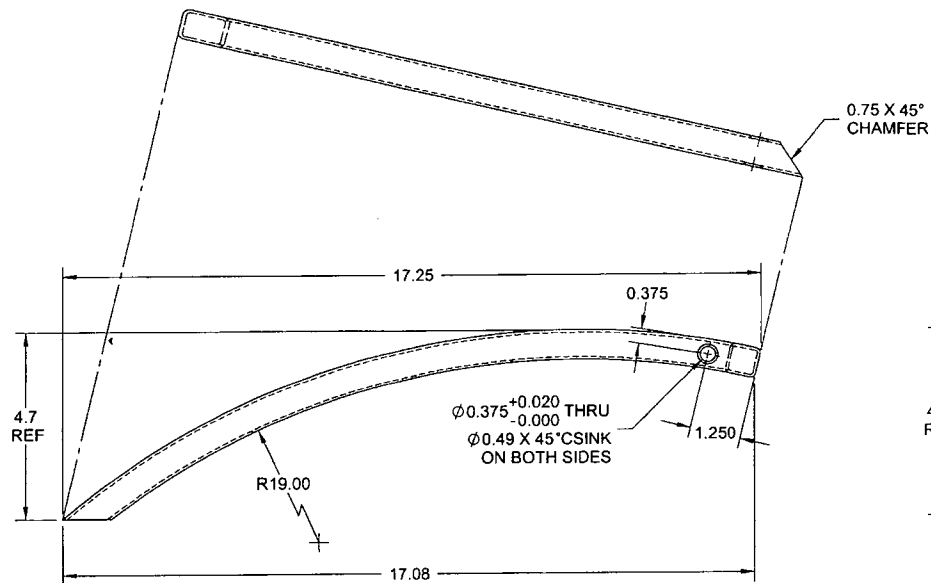
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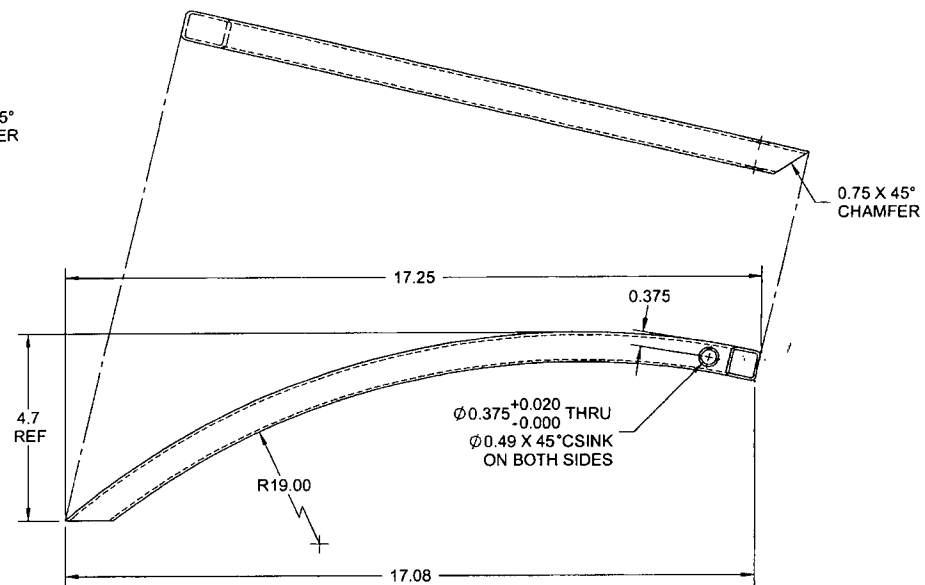
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NOTE: Date & initial all entries



D3852-1 RIB



D3852-2 RIB

w/o 56190

RELEASED
08/11/2008

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs EACH

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
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